

167.64

Date: Wednesday, 1/18/2006 4:04:34 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASSEMBLY
Job Number : 25556A	
Estimate Number : 10278	
P.O. Number : N/A	Part Number : D3121141
This Issue : 1/18/2006 S.O. No. : N/A	Drawing Number : D3121 REV C2
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : C2
Previous Run : 25454	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 2/15/2006 Qty: 12 Um: Each
Checked & Approved By : <u>SEE ABOVE DATE & USER</u>	
Comment : Est Rev:Pick:A 04.02.18 New issue KJ/DS	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M174B1000X02000	17-4 SS Bar
-----	-----------------	-------------



Comment: Qty.: 0.5775 f(s)/Unit Total: 6.9300 f(s)
 Material: 17-4 SS Bar per AMS 5604/5643
 (M17-4-B1.000x02.000)
 Identify for D3121-111
 Batch: M19712

M8 06/02/10

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blanks: (1.000" x 2.000") 6.600" long

JL/SA 06.02.13 12

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111

2-Deburr

3-Scribe batch number

JL/SA 06.02.13 12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/SA 06.02.13 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/22

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.02.15	3	Qty (2) D3121-111 : the thickness is 0.111" thick instead of 0.130"	CP 06.02.15 per QSI 042	Margins are negative SCRAP PARTS + replace	J.L 06.02.15	2 06.02.22	CP 06.02.15 per QSI 042	06.02.22
06.02.15	3	Qty (1) D3121-111 : teeth only 0.020" deep on one edge.	CP 06.02.20 per QSI 042	PART IS OK PER EMAIL (Attached)	J.L 06.02.15	2 06.02.22	CP 06.02.20 per QSI 042	06.02.22

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:04:34 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 25556A

Part Number: D3121141

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ml 06/02/15

6.0

D312121

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-21

Bolt *B25456*

J.L 06.02.15

7.0

D3121241

Bearing Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3121-241 Bearing Ass

B25225

J.L 06.02.15

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3121-141 as per Dwg D3121.

J.L 06.02.15

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 06/02/20

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5408*

06/21 (12)

11.0

DC

DOCUMENT CONTROL



(12)

Comment: DOCUMENT CONTROL

Inspection Level 21

545 06/02/22

(12)

06/02/22

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries


DART AEROSPACE LTD		Work Order: 25556A
Description: Bracket		Part Number: D3121-111
Inspection Dwg: D3121	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.18	+/-0.030					
5.90	+/-0.030					
5.89	+/-0.030					
0.019	+/-0.010					
0.320	+/-0.010					
0.573	+/-0.010					
2.14	+/-0.030					
0.950	+/-0.010					
0.664	+/-0.010					
1.96	+/-0.030					
0.98	+/-0.030					
0.280	+/-0.010					
3.330	+/-0.010					
3.630	+/-0.010					
4.580	+/-0.010					
Ø0.392	+0.002/-0.000					
0.750	+/-0.010					
R0.25	+/-0.030					
0.130	+/-0.010					
0.400	+/-0.010					
0.201	+/-0.010					
0.580	+/-0.010					
0.381	+/-0.010					
0.032	+/-0.010					

Same as
W/O 25557A
Set-P
Same

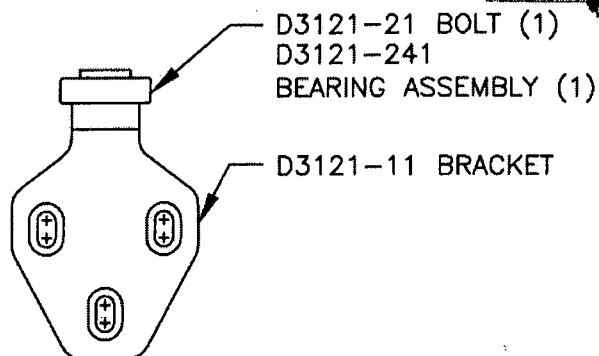
Measured by: 	Audited by:	Prototype Approval: N/A
Date: 06.02.13	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue	KJ/RF	



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 1 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
C1	CP# 04.03.26	3.97 WAS 4.00; 6.11 WAS 6.14	
C2	# 04.04.26	0.230 WAS 0.238	

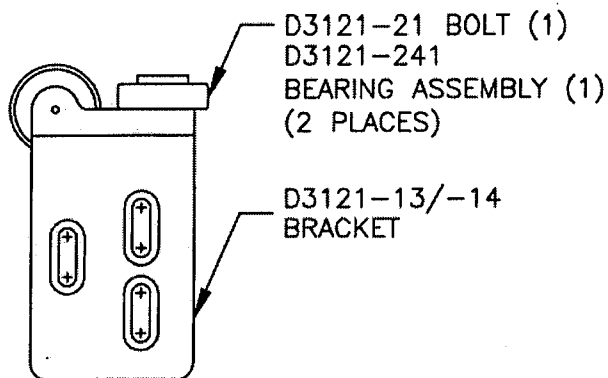
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04.03.01



D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-11 BRACKET

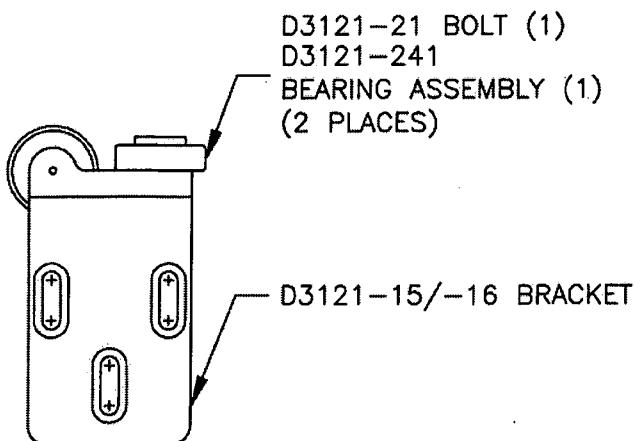
D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)
(2 PLACES)

D3121-13/-14
BRACKET

**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)
(2 PLACES)

D3121-15/-16 BRACKET

**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY**
(REPLACES PREMIER P/N B30-23000-35/-36)

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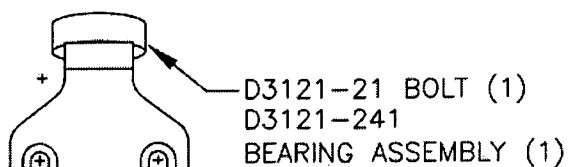
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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2

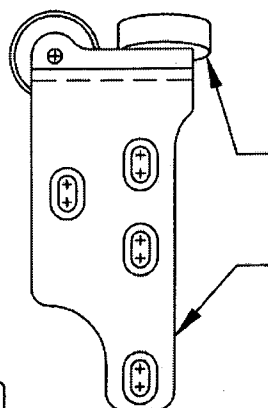


D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-111 BRACKET

D3121-141 BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23001-01)

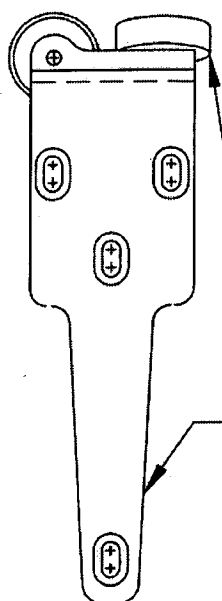


D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-115/-116
BRACKET

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY**

(REPLACES PREMIER P/N B30-23000-05/-06)

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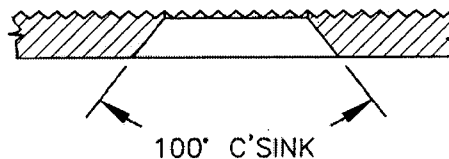
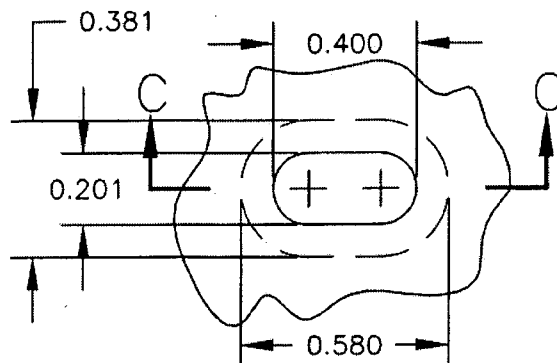
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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

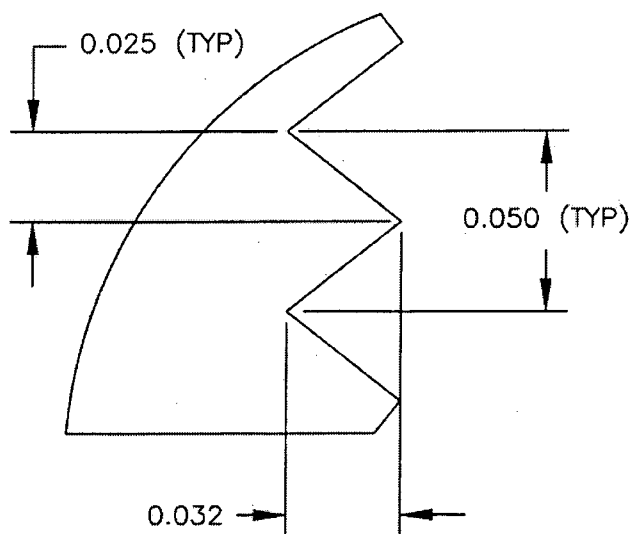
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DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



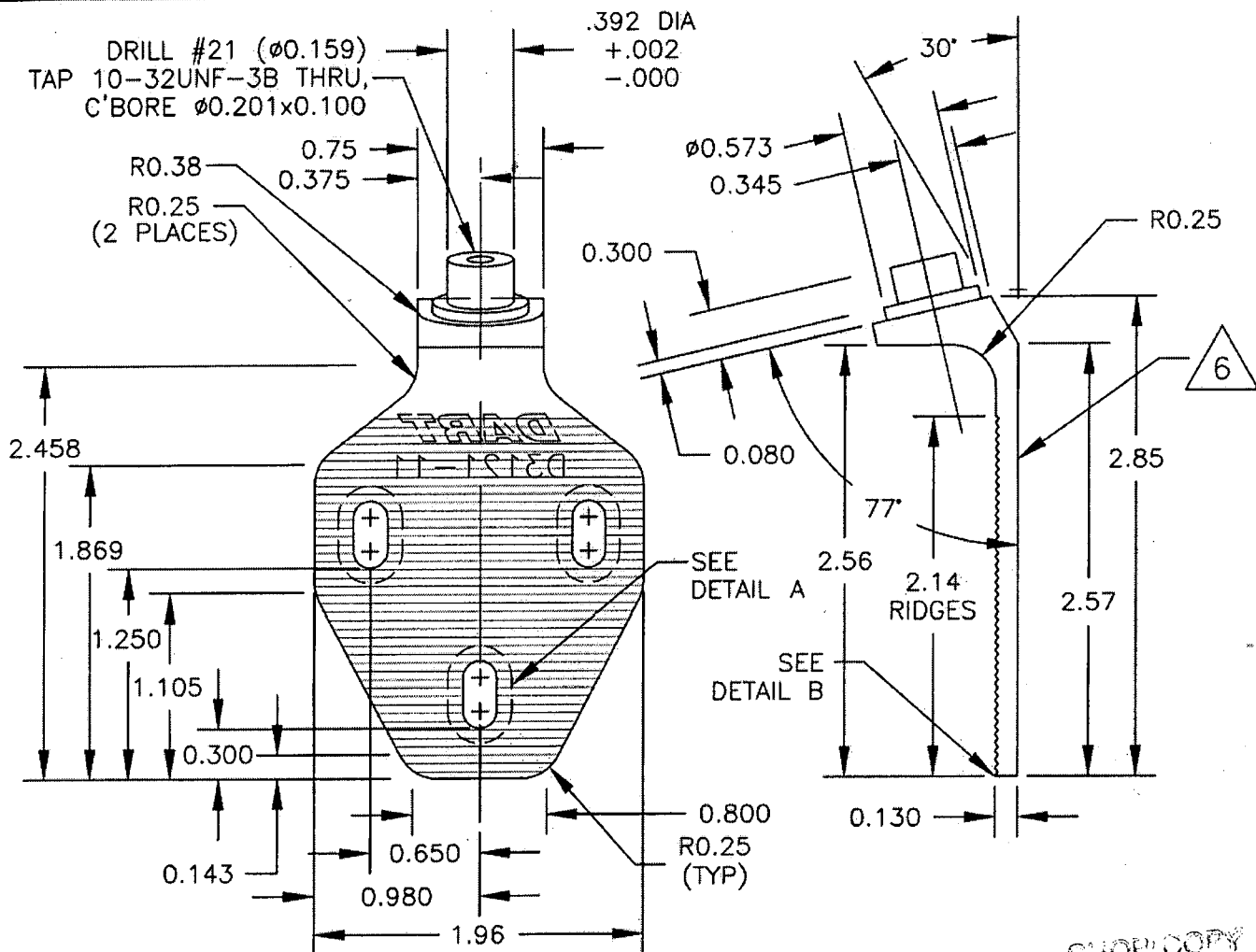
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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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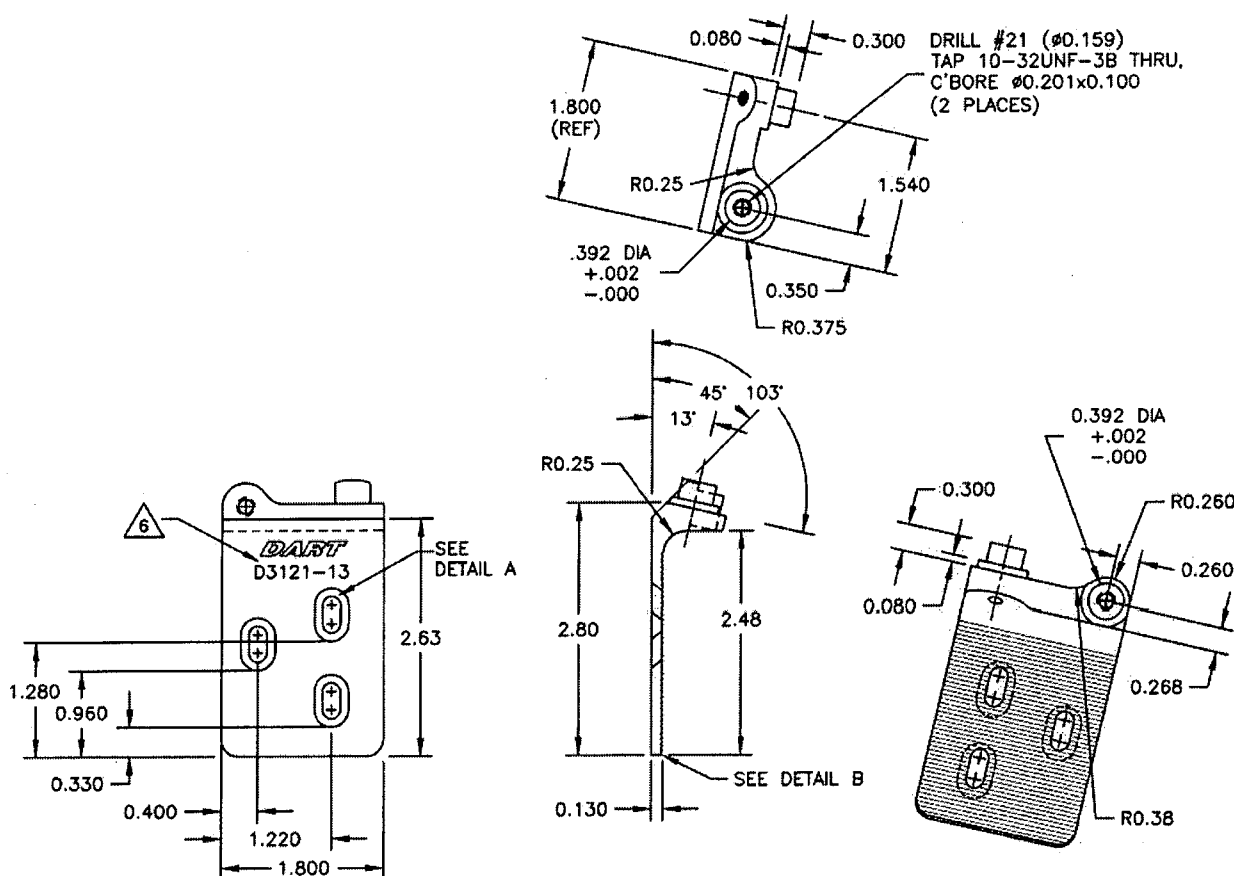
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DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



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D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

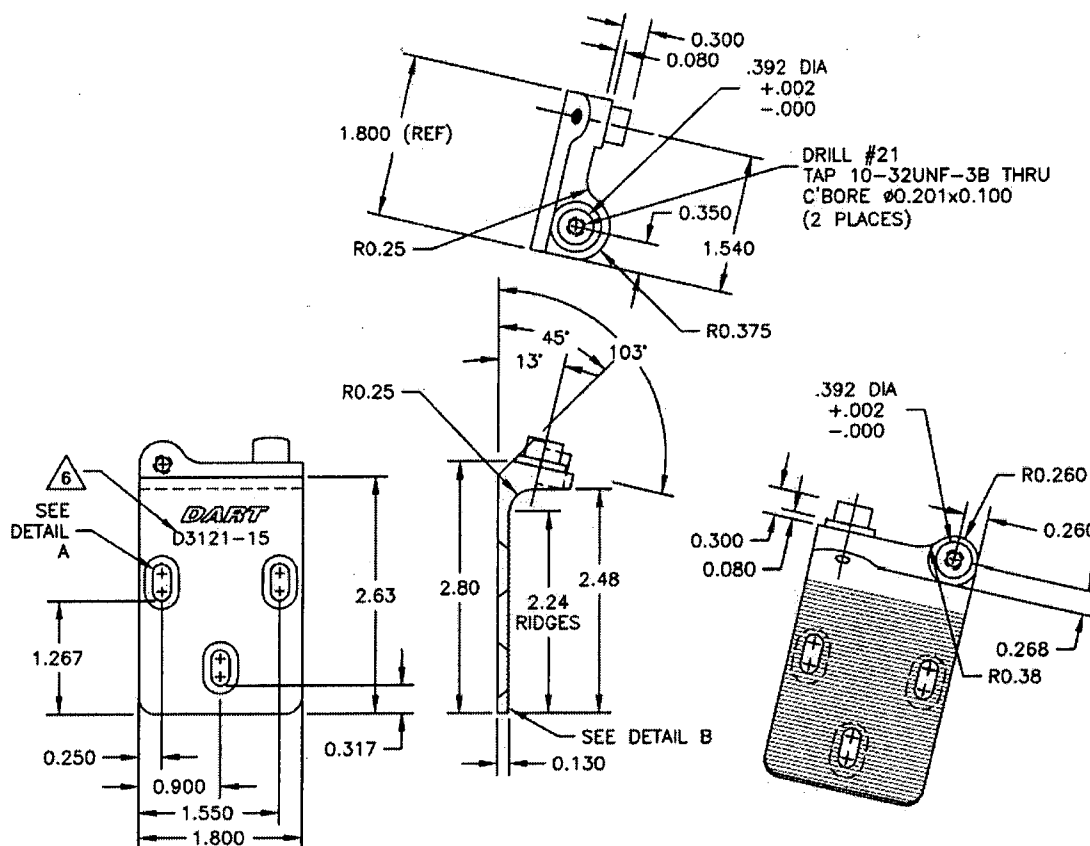
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-15 BRACKET (SHOWN)
D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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NO 25556 A

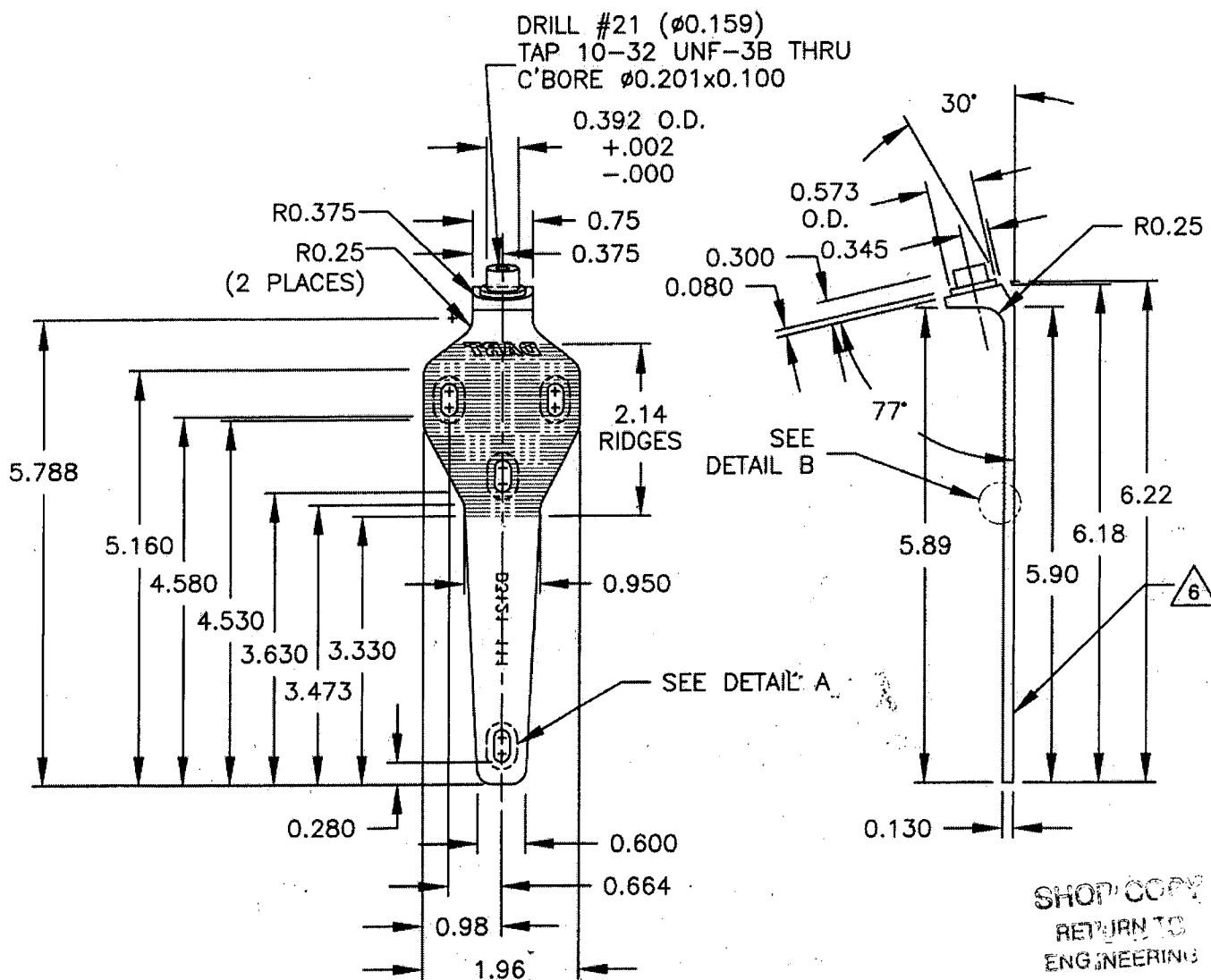
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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 7 OF 10
DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2



D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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WORK IN PROGRESS

25556A

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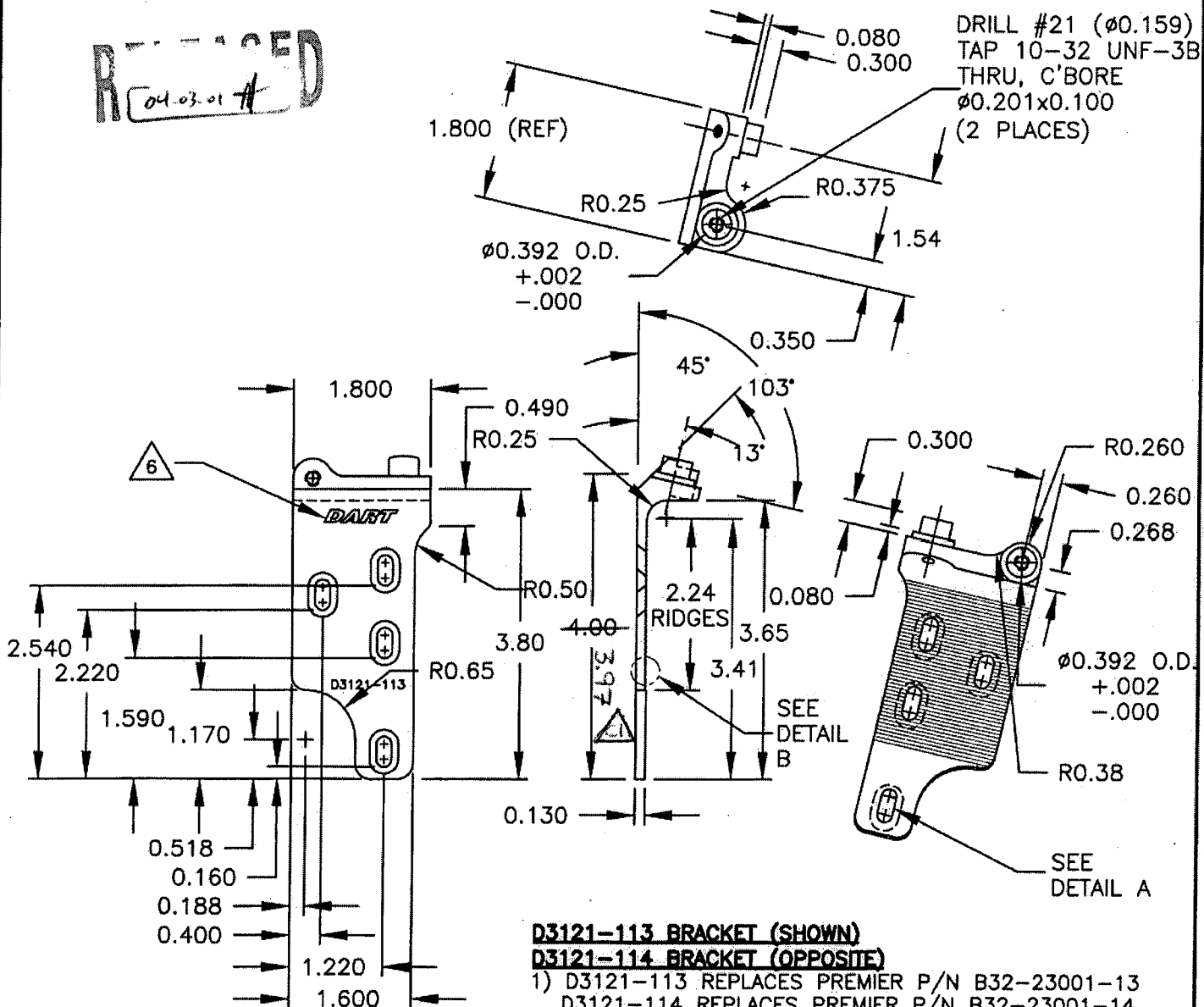
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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3121	REV. C SHEET 8 OF 10
DATE 04.02.18	TITLE BRACKET ASSEMBLY		SCALE 1:2

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04.03.01 *[Signature]*



D3121-113 BRACKET (SHOWN)

D3121-114 BRACKET (OPPOSITE)

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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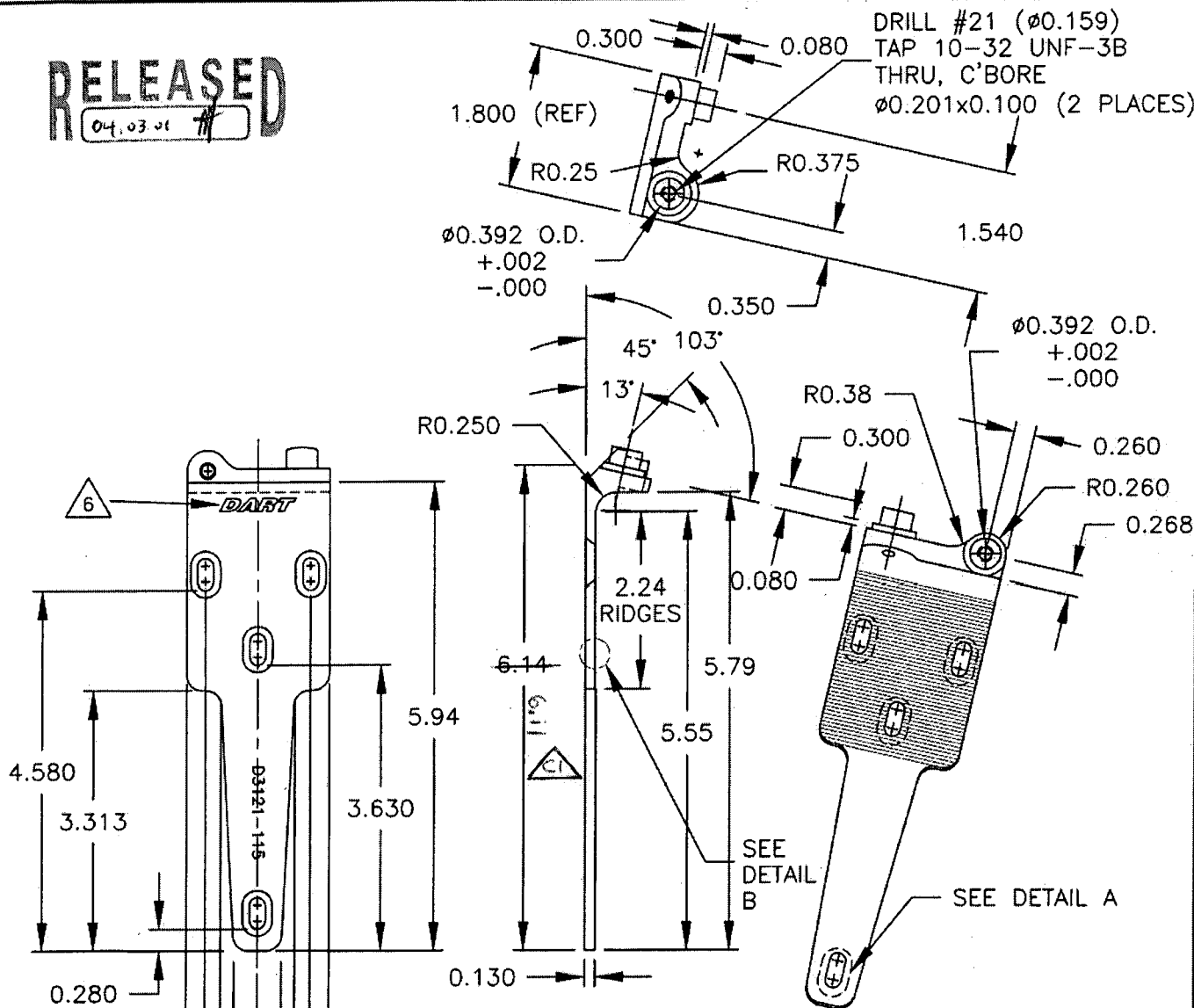
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NO. 25556A



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. C SHEET 9 OF 10
DATE 04.02.18		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED
04.03.01



D3121-115 BRACKET (SHOWN)

D3121-116 BRACKET (OPPOSITE)

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

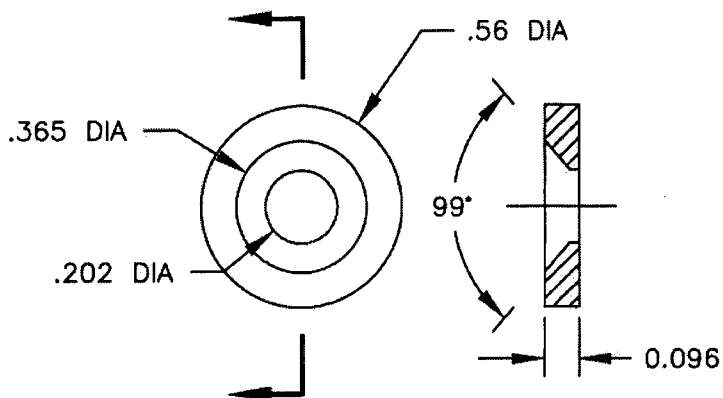
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WORK ORDER
NO. 25356A

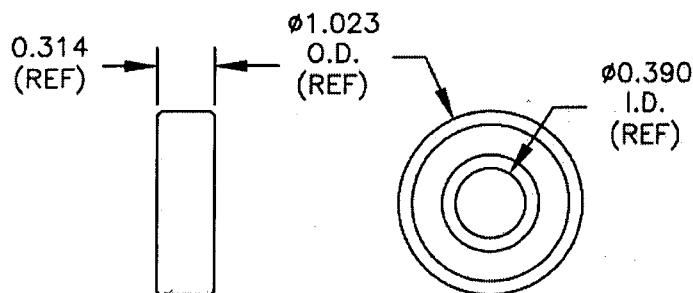


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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 10 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



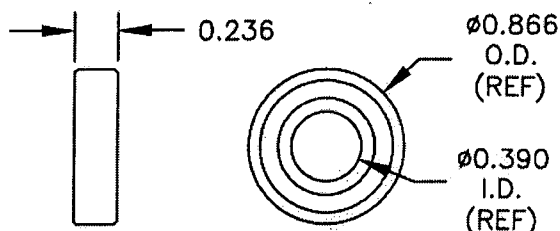
D3121-17 WASHER (SCALE 1:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



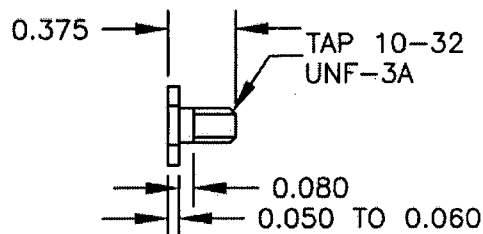
D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



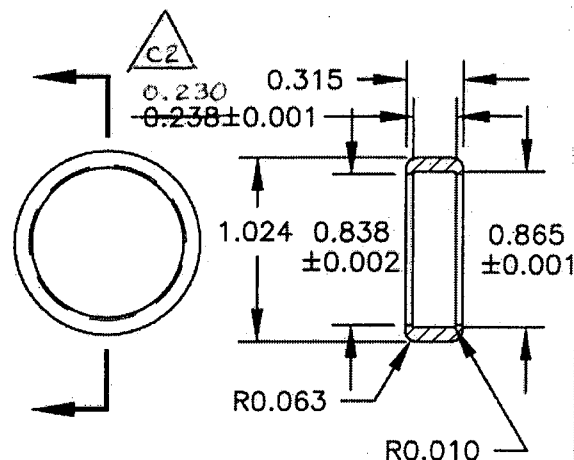
D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES



D3121-21 BOLT (SCALE 1:1)

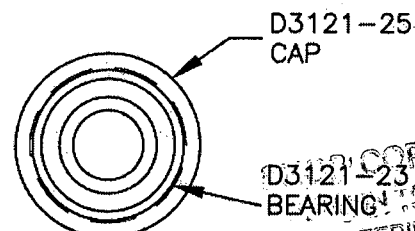
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, 0.125 (REF DART SPEC. M-DELIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.03.01



D3121-241 BEARING ASSEMBLY (SCALE 1:1)

D3121-23 BEARING
D3121-25 CAP
D3121-241 BEARING ASSEMBLY
WORK ORDER NO. 25556A

Chris Provencal

From: David Shepherd [davids@dartaero.com]
Sent: February 16, 2006 1:50 PM
To: Chris Provencal
Subject: Re: ncrs

D3121-111 is acceptable.

With respect to D3137-7, I would double check the stress margins on 0.150" thickness instead of 0.162". If that is OK, then I would think that this part would be acceptable, as long as they blend out the transition line.

David

----- Original Message -----

From: "Chris Provencal" <cprovencal@dartaero.com>
To: <davids@dartaero.com>
Sent: Thursday, February 16, 2006 9:10 AM
Subject: ncrs

> NCRs:

>

> D3121-111, teeth depth goes from nominal 0.032" to under to tolerance at
> 0.020". Part meshes OK, problem is not really noticable on general
> inspection. I think its OK.

>

> D3137-7, thicknes is 0.150", except raised area (shown in picture) which
is

> 0.173". The dwg says the thickness should be 0.162". The was some tool
> problem and it lifted off the tool or something. The can blend out the
> ridge, but I'm thicking it should just be scapped.

>

> Sincerely,

> Chris Provencal

> DART Aerospace Ltd.

> Email..cprovencal@dartaero.com

> Phone...613-632-3336

> Fax.....613-632-4443

>

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